

**Work Order ID 58802**

Wednesday, May 19, 2010 9:22:01 AM



Page 1

Item ID: D350-636-012

Accept



Setup Start



Revision ID:

Item Name: Skidtube RH

Stop



Start Date: 5/18/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 5/25/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

*PL*Date: *10-5-19*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D2750

Rev F

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-012 CHG 005

*8 10/06/10**RJ FSC 10/06/10*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 2

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QtyReject  
QtyReject  
NumberInsp.  
Stamp

110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 5 (D2750-2 details).Drill using drill Jig DT8150 &amp; DT8863 .

3- Mark fwd end for cutting using Drill Jig DT 8150 &amp; DT8863 and cut as per dwg D2750. Deburr.

4- Drill fwd step holes using DT9616. Ensure proper positioning.

5-Drill pilot holes for blade fitting bolts using DT8983. Open to 0.500"

6- locate DT8329 off of blade fitting bolt holes and drill pilot holes blade fitting.

7-Open up holes for Detail K to 0.375" (4 holes per side) blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open holes for ground handling and detail L to 0.500" (8 holes per side)

8-Drill pilot holes for wearplates as per Dwg D2750 using DT8108. Open to 0.297".

9-Open up holes of Detail J to 0.297" (total of 2 holes per side)

10-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004

A/R ☐ Aluminum Rod

Batch: M112860

BE

10/05/26

10-5-26

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[illegible]

Page 3

**Accept**

[illegible]**Setup Start**

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1 111111 111111 111111

**Cust Item ID:**

**Customer:**

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**Stop**



### Operation Description

## Set Up/ Run Hours

**Draw  
Number**

**Draw  
Rev.**

## Plan Code

**Accept  
Qty**

Reject  
QtyReject  
Number

**Insp.  
Stamp**

11-Grind welds flush as per Dwg D2750

12- scribe batch #.

M 10/5/2.6

QC10- Inspect visual per QSI004- ground welds

0.00

[illegible]

QC

## Memo

0.00

## Quality Control

8.10.5/26

QC5- Inspect part completeness to step on W/O

0.00

1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39 40 41 42 43 44 45 46 47 48 49 50 51 52 53 54 55 56 57 58 59 60 61 62 63 64 65 66 67 68 69 70 71 72 73 74 75 76 77 78 79 80 81 82 83 84 85 86 87 88 89 90 91 92 93 94 95 96 97 98 99 100 101 102 103 104 105 106 107 108 109 110 111 112 113 114 115 116 117 118 119 120 121 122 123 124 125 126 127 128 129 130 131 132 133 134 135 136 137 138 139 140 141 142 143 144 145 146 147 148 149 150 151 152 153 154 155 156 157 158 159 160 161 162 163 164 165 166 167 168 169 170 171 172 173 174 175 176 177 178 179 180 181 182 183 184 185 186 187 188 189 190 191 192 193 194 195 196 197 198 199 200 201 202 203 204 205 206 207 208 209 210 211 212 213 214 215 216 217 218 219 220 221 222 223 224 225 226 227 228 229 230 231 232 233 234 235 236 237 238 239 240 241 242 243 244 245 246 247 248 249 250 251 252 253 254 255 256 257 258 259 260 261 262 263 264 265 266 267 268 269 270 271 272 273 274 275 276 277 278 279 280 281 282 283 284 285 286 287 288 289 290 291 292 293 294 295 296 297 298 299 300 301 302 303 304 305 306 307 308 309 310 311 312 313 314 315 316 317 318 319 320 321 322 323 324 325 326 327 328 329 330 331 332 333 334 335 336 337 338 339 340 341 342 343 344 345 346 347 348 349 350 351 352 353 354 355 356 357 358 359 360 361 362 363 364 365 366 367 368 369 370 371 372 373 374 375 376 377 378 379 380 381 382 383 384 385 386 387 388 389 390 391 392 393 394 395 396 397 398 399 400 401 402 403 404 405 406 407 408 409 410 411 412 413 414 415 416 417 418 419 420 421 422 423 424 425 426 427 428 429 430 431 432 433 434 435 436 437 438 439 440 441 442 443 444 445 446 447 448 449 450 451 452 453 454 455 456 457 458 459 460 461 462 463 464 465 466 467 468 469 470 471 472 473 474 475 476 477 478 479 480 481 482 483 484 485 486 487 488 489 490 491 492 493 494 495 496 497 498 499 500 501 502 503 504 505 506 507 508 509 510 511 512 513 514 515 516 517 518 519 520 521 522 523 524 525 526 527 528 529 530 531 532 533 534 535 536 537 538 539 540 541 542 543 544 545 546 547 548 549 550 551 552 553 554 555 556 557 558 559 560 561 562 563 564 565 566 567 568 569 570 571 572 573 574 575 576 577 578 579 580 581 582 583 584 585 586 587 588 589 590 591 592 593 594 595 596 597 598 599 600 601 602 603 604 605 606 607 608 609 610 611 612 613 614 615 616 617 618 619 620 621 622 623 624 625 626 627 628 629 630 631 632 633 634 635 636 637 638 639 640 641 642 643 644 645 646 647 648 649 650 651 652 653 654 655 656 657 658 659 660 661 662 663 664 665 666 667 668 669 670 671 672 673 674 675 676 677 678 679 680 681 682 683 684 685 686 687 688 689 690 691 692 693 694 695 696 697 698 699 700 701 702 703 704 705 706 707 708 709 710 711 712 713 714 715 716 717 718 719 720 721 722 723 724 725 726 727 728 729 730 731 732 733 734 735 736 737 738 739 740 741 742 743 744 745 746 747 748 749 750 751 752 753 754 755 756 757 758 759 760 761 762 763 764 765 766 767 768 769 770 771 772 773 774 775 776 777 778 779 780 781 782 783 784 785 786 787 788 789 790 791 792 793 794 795 796 797 798 799 800 801 802 803 804 805 806 807 808 809 810 811 812 813 814 815 816 817 818 819 820 821 822 823 824 825 826 827 828 829 830 831 832 833 834 835 836 837 838 839 840 841 842 843 844 845 846 847 848 849 850 851 852 853 854 855 856 857 858 859 860 861 862 863 864 865 866 867 868 869 870 871 872 873 874 875 876 877 878 879 880 881 882 883 884 885 886 887 888 889 890 891 892 893 894 895 896 897 898 899 900 901 902 903 904 905 906 907 908 909 910 911 912 913 914 915 916 917 918 919 920 921 922 923 924 925 926 927 928 929 930 931 932 933 934 935 936 937 938 939 940 941 942 943 944 945 946 947 948 949 950 951 952 953 954 955 956 957 958 959 960 961 962 963 964 965 966 967 968 969 970 971 972 973 974 975 976 977 978 979 980 981 982 983 984 985 986 987 988 989 990 991 992 993 994 995 996 997 998 999 1000 1001 1002 1003 1004 1005 1006 1007 1008 1009 1010 1011 1012 1013 1014 1015 1016 1017 1018 1019 1020 1021 1022 1023 1024 1025 1026 1027 1028 1029 1030 1031 1032 1033 1034 1035 1036 1037 1038 1039 1040 1

QC

## Memo

0.00

## Quality Control

8/10/5/26

AL

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Page 4

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Customer:

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
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DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

Hand Finishing

1 10/5/26.

150



QC

QC3- Inspect Part Finish

0.00

Memo

0.00

Quality Control

10-5-26

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Page 5

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Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							
	Skidtubes								
Skidtubes									
Skidtubes									
	<b>Memo</b>	0.00							
	1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.								
	2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.								
	3-Open float holes to .500" (4 per Side)								
	4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)								
	5-Deburr and blow out all chips from inside of tube								
	6-Prepare tube for welding, remove alodine as required.								
	7-Bond web D2739 in place as per QSI 015								
	A/R <input type="checkbox"/> Sikaflex-291 batch: <u>M113435</u> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>								
	exp. date: <u>12/11/20</u>								
	8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9)								
	A/R <input type="checkbox"/> Aluminum Rod batch: <u>M112860</u>								
	9- At section AP-AP drill out x-bolt spacer to 0.404"								
	10-Grind welds flush as per Dwg D2750								
	11-Spot face ground handling holes section (total of 4 places per side) as per								

M 10/15/27

BE 10/05/27

BE 10/05/27

M 10/15/27

W/O:		WORK ORDER CHANGES					
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Page 6

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
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Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

dwg D2750

12-Deburr holes

M125/31

170



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

8.10.6.5.13.1

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8.10.6.5.13.1

⑩

W/O:		WORK ORDER CHANGES					
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Page 7

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Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

1 BL 10.5-1

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 1:45pm  
OVEN TEMPERATURE: 320°C  
FINISH TIME: 2:15pm

=> 10/06/01

1 0

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

10 06 08 01

W/O:		WORK ORDER CHANGES					
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NumberInsp.  
Stamp

220

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

Install inserts as per dwg D2750

m 10 06 08 ①

230

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Inspect for Foreign Objects

~~2-Spray inside of tube with "LPS-3"~~ N/A m 10.06.08  
batch: \_\_\_\_\_3-Install blade fitting D3488-042, wearshoes and ground handling hardware as  
per dwg D2750

SIKA FLEX 241

BATCH: 118435

EXP DATE: 10/11

4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube  
A/R 55-o'ring lube batch: 1141895-Coat all exposed fasteners with "LPS Procyon"  
batch: 104251

m 10 06 08 ①

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Page 9

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240

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/06/08

(A)

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10-6 95

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8/10/06/10

(AL)

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Page 10

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QtyReject  
NumberInsp.  
Stamp

270

0.00



Packaging

Packaging

Memo

0.00

Packaging

Package as per PPP D350-636-012

RCH

10-6-10 SL

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/10

B-58802

u 12-06-10

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, May 19, 2010 9:22:06 AM

Page 1

Work Order ID: 58802

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ  
 IPP Rev: J 06-03-29 As per Rev D EC  
 IPP Rev: K 06-07.13 As per dsi9343 EC  
 IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By: EC

Start Date: 5/18/2010

Required Date: 5/25/2010

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

Purchased

No

220

Each

7,062.000

38



Insert

Location

Loc Qty

Loc Code

PK011

7062

110768

7062

AN3C5A

Purchased

No

230

Each

453.0000

34



Bolt

Location

Loc Qty

Loc Code

ST350

325

114330

125

114523

200

ST351

128

113121

10

114108

45

114181

73

AN3C6A

Purchased

No

230

Each

565.0000

4



BOLT

Location

Loc Qty

Loc Code

ST351

565

111982

565

O-Ring x 8

D2594-3 B58191

M/ 10-06-08 (8x)

M/ 10-06-08

M/ 10-06-08

M/ 10-06-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, May 19, 2010 9:22:06 AM

Page 2

Work Order ID: 58802



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 5/18/2010

Required Date: 5/25/2010

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ  
 IPP Rev: J 06-03-29 As per Rev D EC  
 IPP Rev: K 06-07.13 As per dsi9343 EC  
 IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

AN6C44A Purchased No 230 Each 101.0000 4



BOLT

Location	Loc Qty	Loc Code
FG	2	
103964	2	
ST344	99	
111649	2	
114455	47	
114653	50	

M/ 10-06-08

AN8C35A Purchased No 230 Each 56.0000 1



BOLT

Location	Loc Qty	Loc Code
FP	6	
110847	6	
ST346	50	
114442	50	

M/ 10.06.08

~~AN960C10L~~ AN960C10L Purchased No 230 Each 0.0000 38



washer

AN960C816L Purchased No 230 Each 106.0000 1



WASHER

Location	Loc Qty	Loc Code
ST348	106	
110584	100	
111424	6	

M/ 10.06.08

M/ 10 06 08

Wednesday, May 19, 2010 9:22:06 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Wednesday, May 19, 2010 9:22:06 AM

Page 3

Work Order ID: 58802



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 5/18/2010

Required Date: 5/25/2010

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ

Start Qty: 1.00

Required Qty: 1.00

IPP Rev: J 06-03-29 As per Rev D EC

IPP Rev: K 06-07.13 As per dsi9343 EC

IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

D2745 Manufactured No 230 Each 146.0000 8



Bushing

Location Loc Qty Loc Code

ST023 146

52311 69

57914 77

D3488-042 Manufactured No 230 Each 19.0000 1



Blade Fitting Assembly, RH

Location Loc Qty Loc Code

FP008 19

53918 19

D3492-041 Manufactured No 230 Each 98.0000 8



Plug Assembly

Location Loc Qty Loc Code

FP013 98

57915 38

58180 60

D3492-043 Manufactured No 230 Each 61.0000 8



Plug Assembly

Location Loc Qty Loc Code

FP 2

54682 2

FP013 59

57916 59

Wednesday, May 19, 2010 9:22:06 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, May 19, 2010 9:22:06 AM

Page 4

Work Order ID: 58802

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ  
 IPP Rev: J 06-03-29 As per Rev D EC  
 IPP Rev: K 06-07.13 As per dsi9343 EC  
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Date: 5/18/2010

Required Date: 5/25/2010

Start Qty: 1.00

Required Qty: 1.00

D3535-25 Manufactured No 230 Each 13.0000 1  
 Wearshoe

Location	Loc Qty	Loc Code
FP18	13	
57943	13	

mt 10.08.08

D3536-25 Manufactured No 230 Each 6.0000 1  
 Gasket

Location	Loc Qty	Loc Code
FP12	6	
57944	6	

mt 10.06.08

D3537-1 Manufactured No 230 Each 24.0000 3  
 Wearpad

B#58178

Location	Loc Qty	Loc Code
FP	1	
55465	1	
FP17	23	
57256	23	

mt 10.06.08

D3631-1 Manufactured No 230 Each 206.0000 8  
 Washer

\*

B#54388

Location	Loc Qty	Loc Code
ST076	206	
52693	206	

mt 10.06.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, May 19, 2010 9:22:06 AM

Page 5

Work Order ID: 58802



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 5/18/2010

Required Date: 5/25/2010

Comments: IPP Rev: I ☐ 02.09.25 ☐ Rearranged procedure steps ☐ KJ ☐  
IPP Rev: J 06-03-29 As per Rev D EC  
IPP Rev: K 06-07.13 As per dsi9343 EC  
IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D3672-1 Manufactured No 230 Each 1,375.000 4



Phenolic Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST077	1375	
51674	375	
52505	1000	

*mt* 10.06.08

D3791-1 Manufactured No 230 Each 5.0000 1



Wearplate

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP17	5	
56299	5	

*mt* 10.06.08

D3793-1 Manufactured No 230 Each 10.0000 1



Wearshoe

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP18	10	
56300	1	
57945	9	

*mt* 10.06.08

D3793-3 Manufactured No 230 Each 11.0000 1



Wearshoe

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP19	11	
57947	11	

*mt* 10.06.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, May 19, 2010 9:22:06 AM

Page 6

Work Order ID: 58802



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 5/18/2010

Required Date: 5/25/2010

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ  
 IPP Rev: J 06-03-29 As per Rev D EC  
 IPP Rev: K 06-07.13 As per dsi9343 EC  
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D3794-1 Manufactured No 230 Each 32.0000 1  
 Gasket

Location	Loc Qty	Loc Code
FP010	26	
57942	26	
FP014	6	
57537	6	

MM 10.06.08

D3794-3 Manufactured No 230 Each 14.0000 1  
 Gasket

B#59153

Location	Loc Qty	Loc Code
FP18	14	
56066	14	

MM 10.06.08

MS21043-6 Purchased No 230 Each 826.0000 4  
 NUT

Location	Loc Qty	Loc Code
ST301	826	
112314	826	

MM 10.06.08

MS21083C8 Purchased No 230 Each 41.0000 1  
 NUT

Location	Loc Qty	Loc Code
ST303	41	
113845	11	
114523	30	

MM 10.06.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Wednesday, May 19, 2010 9:22:06 AM

Page 7

Work Order ID: 58802

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ  
 IPP Rev: J 06-03-29 As per Rev D EC  
 IPP Rev: K 06-07.13 As per dsi9343 EC  
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Date: 5/18/2010

Required Date: 5/25/2010

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010



O-RING

Purchased No 230 Each 306.0000 8

*NA MF 10-6-10*

Location	Loc Qty	Loc Code
FP	306	
110715	100	
110915	206	

NAS1611-013



O-RING

Purchased No 230 Each 223.0000 8

Location	Loc Qty	Loc Code
FP	223	
114451	185	
114496	38	

*mf 10 06 08*

AN8C21A



BOLT

Purchased No 230 Each 113.0000 2

Location	Loc Qty	Loc Code
ST345	113	
111605	23	
113558	50	
114653	40	

*10-6-9 SP*

AN960C816L



WASHER

Purchased No 250 Each 106.0000 1

Location	Loc Qty	Loc Code
ST348	106	
110584	100	
111424	6	

*10-6-9 SP*

Wednesday, May 19, 2010 9:22:06 AM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, May 19, 2010 9:22:06 AM

Page 8

Work Order ID: 58802

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Comments: IPP Rev: I ☐ 02.09.25 ☐ Rearranged procedure steps ☐ KJ ☐  
IPP Rev: J 06-03-29 As per Rev D EC  
IPP Rev: K 06-07.13 As per dsi9343 EC  
IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Date: 5/18/2010

Required Date: 5/25/2010

Start Qty: 1.00

Required Qty: 1.00

D2741

Manufactured No

250

Each

28.0000

1



Blade, 350 Skidtube



10-6-95

Location

Loc Qty

Loc Code

ST466

28

55905

28

D3493-1

Manufactured No

250

Each

33.0000

2



Washer



10-6-95

Location

Loc Qty

Loc Code

ST065

33

57825

33

D3532-1

Manufactured No

250

Each

25.0000

2



Spacer



10-6-95

Location

Loc Qty

Loc Code

ST068

25

52321

25

D3672-13

Purchased No

250

Each

894.0000

2



Phenolic Washer



10-6-95

Location

Loc Qty

Loc Code

ST077

894

54363

894

Wednesday, May 19, 2010 9:22:06 AM

Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, May 19, 2010 9:22:06 AM

Page 9

Work Order ID: 58802

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ  
 IPP Rev: J 06-03-29 As per Rev D EC  
 IPP Rev: K 06-07.13 As per dsi9343 EC  
 IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By: EC

Start Date: 5/18/2010

Required Date: 5/25/2010

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased No

250 Each

41.0000 1



NUT

Location

Loc Qty

Loc Code

ST303

41

113845

11

114523

30

D2600-3-BENT

Manufactured No

110 Each

2.0000 1



Extrusion Bent

Location

Loc Qty

Loc Code

LG

2

55462

1

57538

1

D2744

Manufactured No

110 Each

28.0000 1



Cap

Location

Loc Qty

Loc Code

LG

28

47488

10

51922

18

D2739

Manufactured No

160 Each

1.0000 1



350 I Beam

Location

Loc Qty

Loc Code

LG

1

57948

1

Wednesday, May 19, 2010 9:22:06 AM

Shop Packet Print

Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, May 19, 2010 9:22:06 AM

Page 10

Work Order ID: 58802



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 5/18/2010

Required Date: 5/25/2010

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ  
IPP Rev: J 06-03-29 As per Rev D EC  
IPP Rev: K 06-07.13 As per dsi9343 EC  
IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D2743 Manufactured No 160 Each 114.0000 8



Crossbolt Spacer



Location	Loc Qty	Loc Code
LG	114	
50281	10	
52310	24	
57953	80	

D3490-3 Manufactured No 160 Each 31.0000 4



Cross Bolt Spacer



Location	Loc Qty	Loc Code
LG	31	
57918	31	

D3490-1 Manufactured No 160 Each 25.0000 4



Cross Bolt Spacer



Location	Loc Qty	Loc Code
LG	25	
57723	25	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



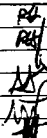
QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

# GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:  
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ( $\phi 0.297$ ) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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WITHOUT NOTICE  
WORK ORDER  
NO. 58802  
BK-5-19

RELEASED

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 1 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

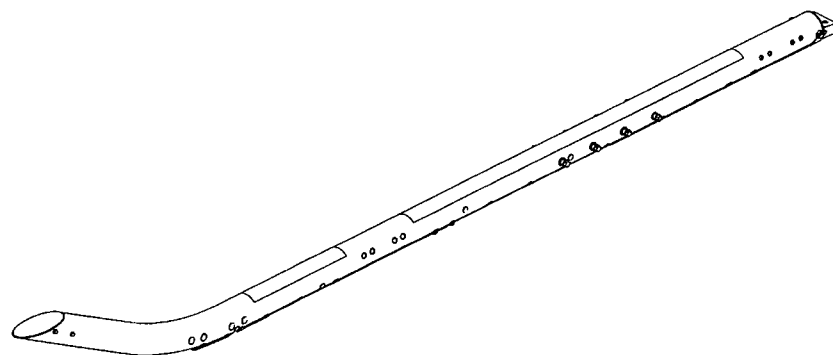
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

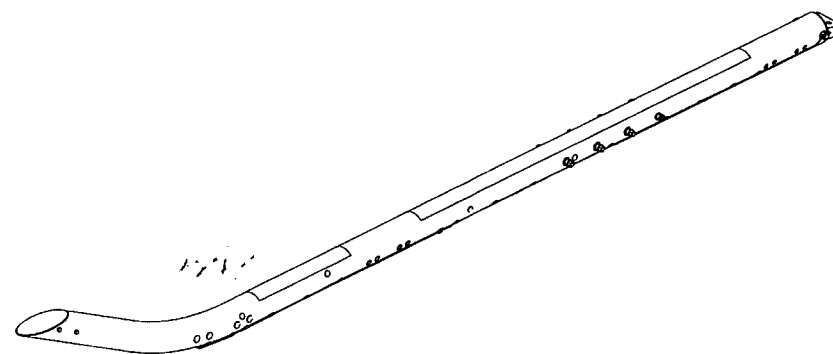
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

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28-9-22-17

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DE APPR.	ME	<b>350 SKIDTUBE ASSEMBLY</b>	NTS
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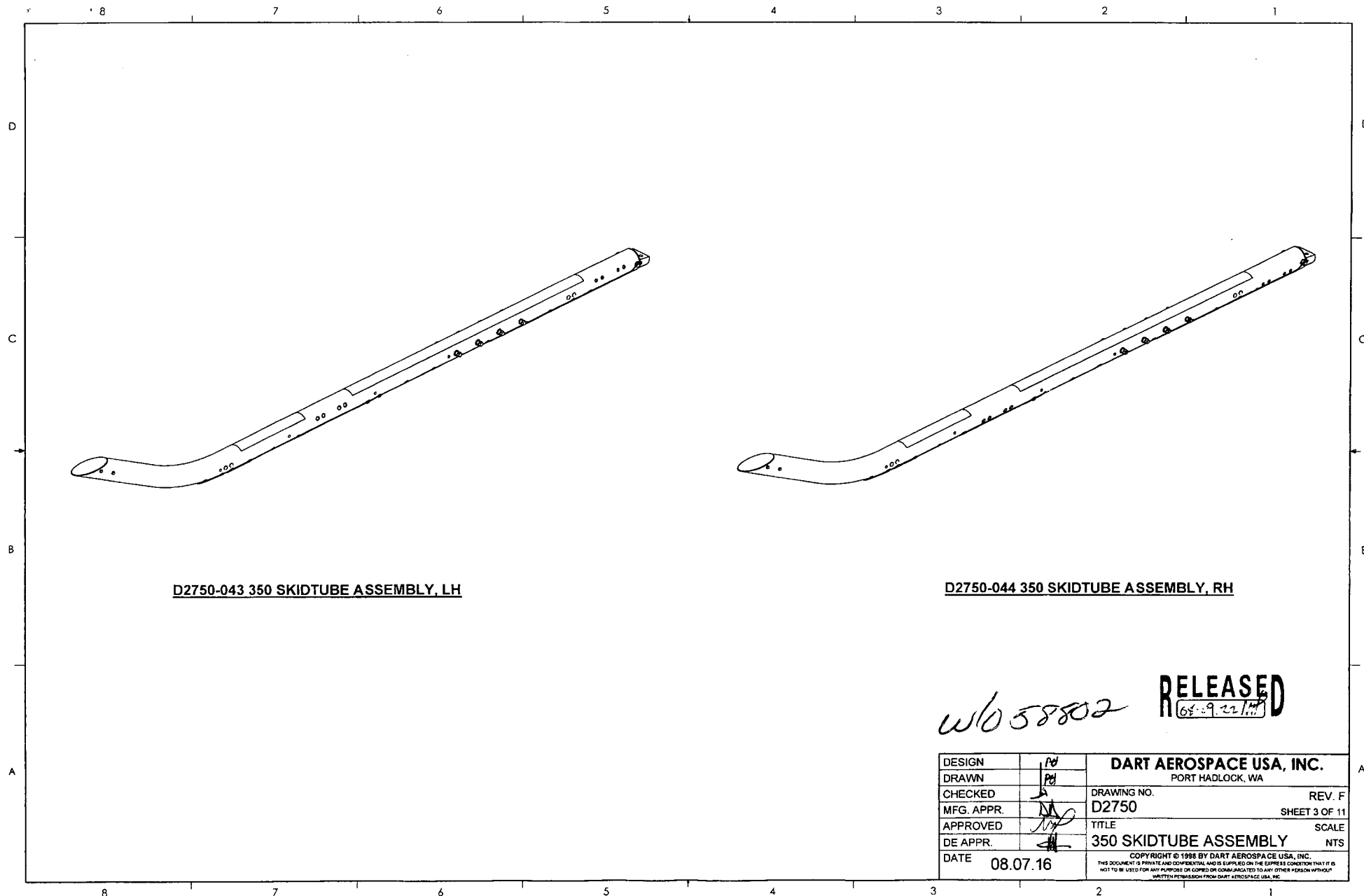
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



D2750-043 350 SKIDTUBE ASSEMBLY, LH

D2750-044 350 SKIDTUBE ASSEMBLY, RH

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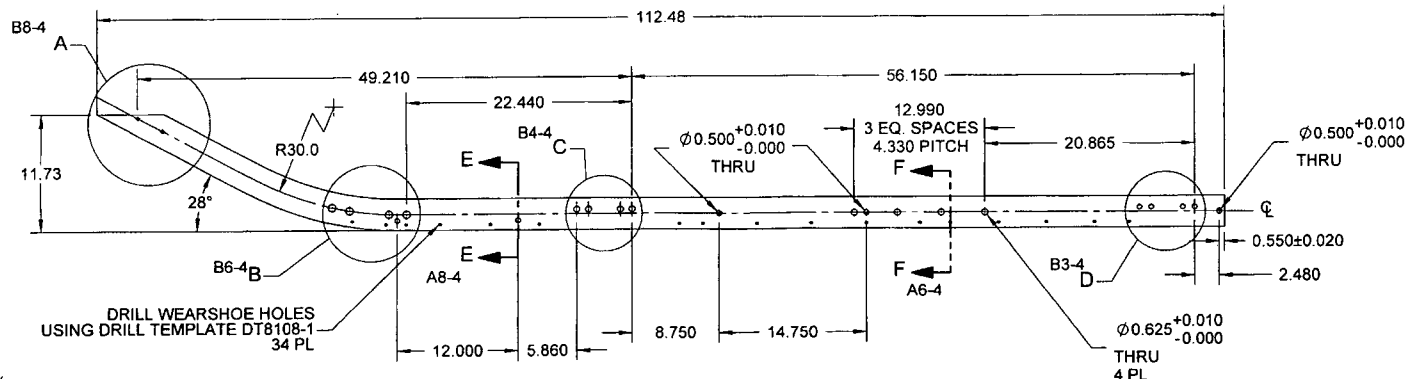
**Dart Aerospace Ltd**

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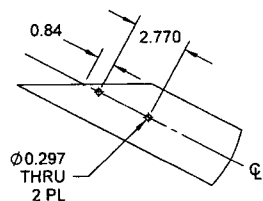
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

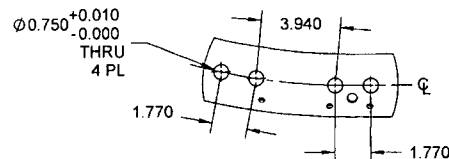
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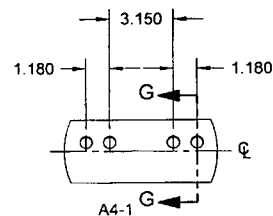
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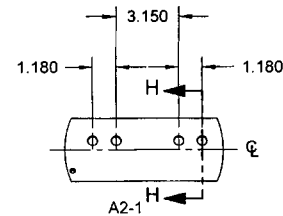
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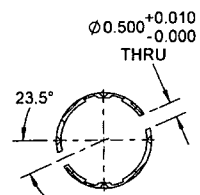
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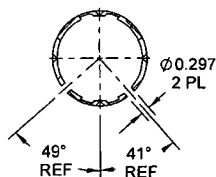
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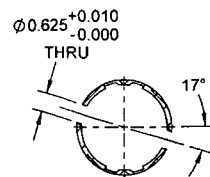
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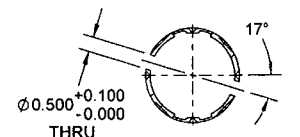
**SECTION E-E**  
SCALE 3X, 2 PL



**SECTION F-F**  
SCALE 3X, 17 PL



**SECTION G-G**  
SCALE 3X, 4 PL



**SECTION H-H**  
SCALE 3X, 4 PL

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CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	08.07.16

**DART AEROSPACE USA, INC.**  
PORT HADLOCK, WA

DRAWING NO. **D2750** REV. F  
TITLE **350 SKIDTUBE ASSEMBLY** SCALE NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

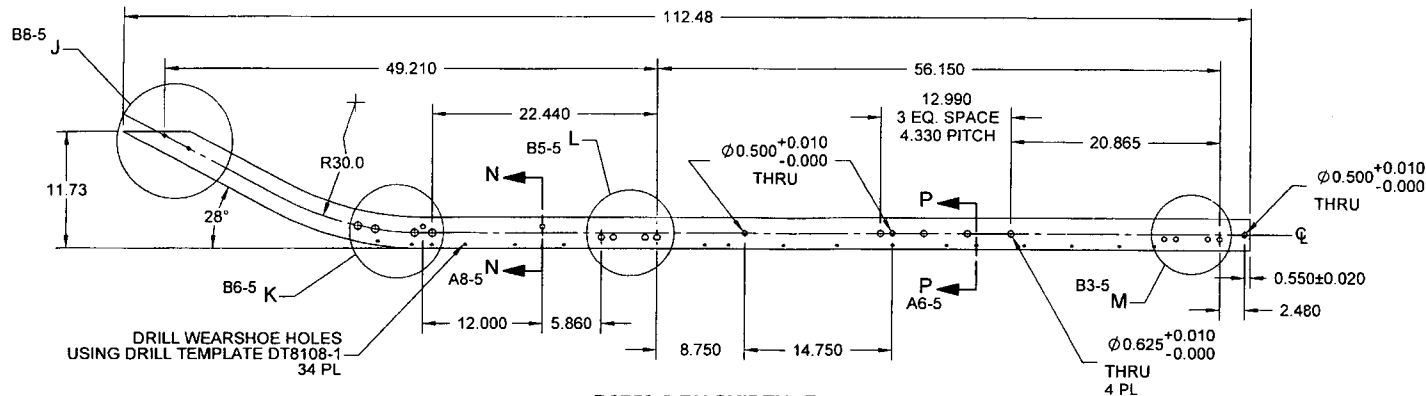
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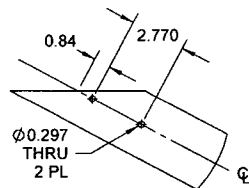
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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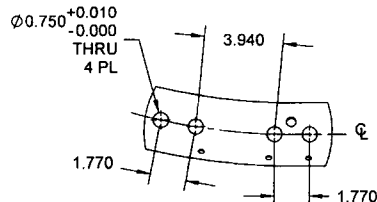




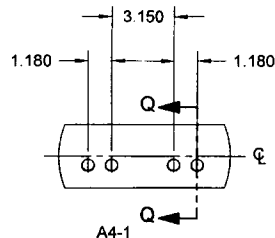
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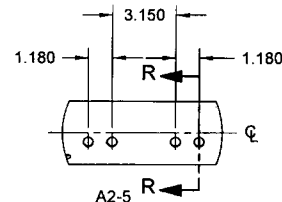
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SCALE 2X



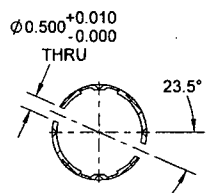
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SCALE 2X



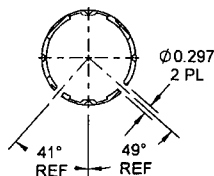
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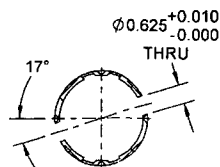
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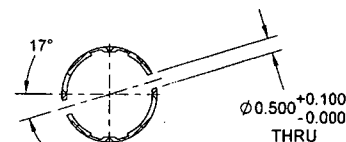
**SECTION N-N**  
SCALE 3X, 2 PL



**SECTION P-P**  
SCALE 3X, 17 PL



**SECTION Q-Q**  
SCALE 3X, 4 PL



**SECTION R-R**  
SCALE 3X, 4 PL

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MFG. APPR.		REV. F
APPROVED		SHEET 5 OF 11
DE APPR.		TITLE <b>350 SKIDTUBE ASSEMBLY</b>
DATE	<b>08.07.16</b>	SCALE <b>NTS</b>

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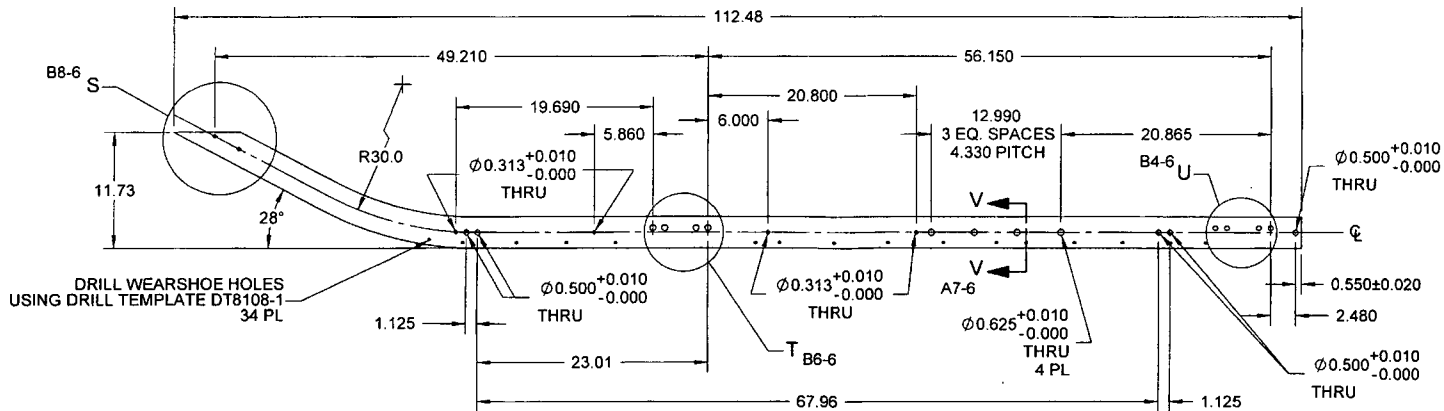
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

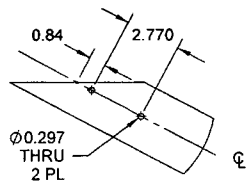
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

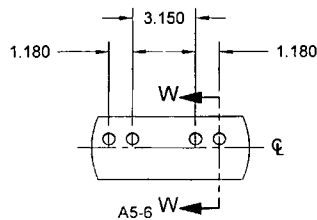
**NOTE:** Date & initial all entries



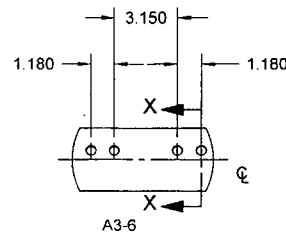
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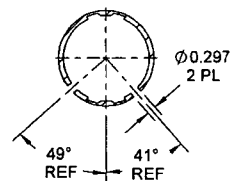
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D8-6



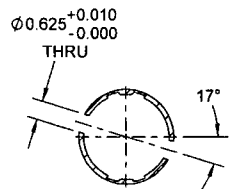
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C5-6



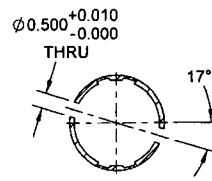
**DETAIL U**  
SCALE 2X  
D3-6



**SECTION V-V**  
SCALE 3X, 17 PL  
C4-6



**SECTION W-W**  
SCALE 3X, 4 PL  
B6-6



**SECTION X-X**  
SCALE 3X, 4 PL  
B4-6

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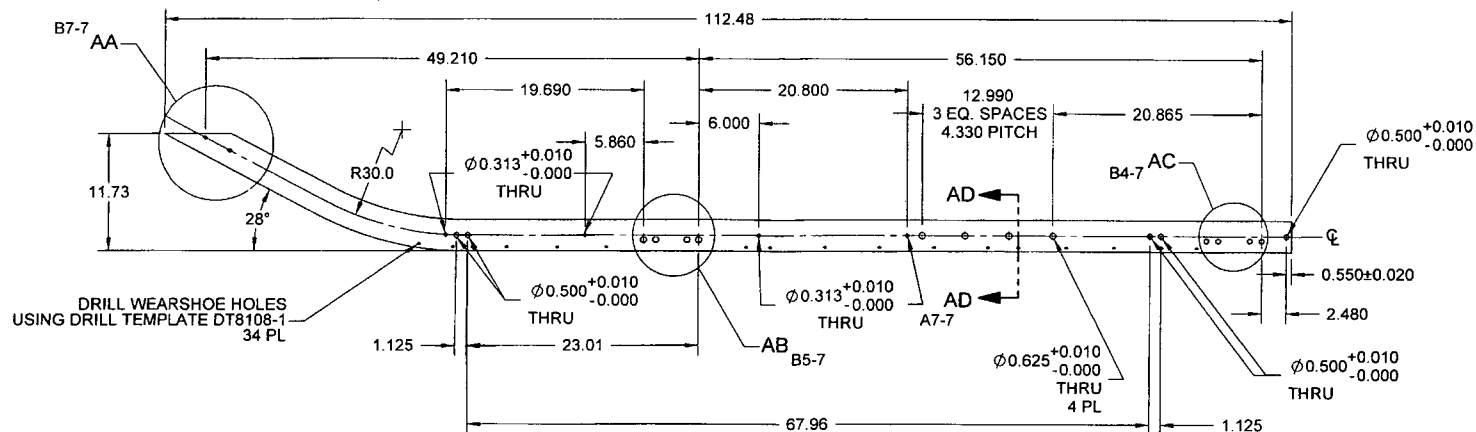
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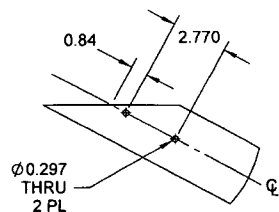
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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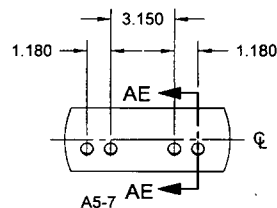
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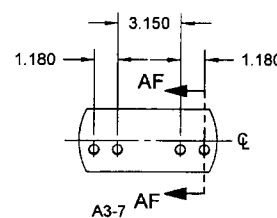
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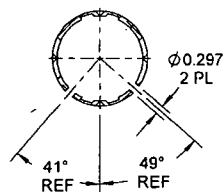
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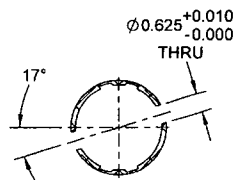
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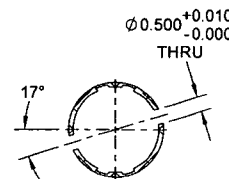
**DETAIL AC**  
SCALE 2X



**SECTION AD-AD**  
SCALE 3X, 17 PL



**SECTION AE-AE**  
SCALE 3X, 4 PL



**SECTION AF-AF**  
SCALE 3X, 4 PL

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DESIGN	<i>RA</i>	<b>DART AEROSPACE USA, INC.</b>	
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MFG. APPR.	<i>RA</i>	D2750	SHEET 7 OF 11
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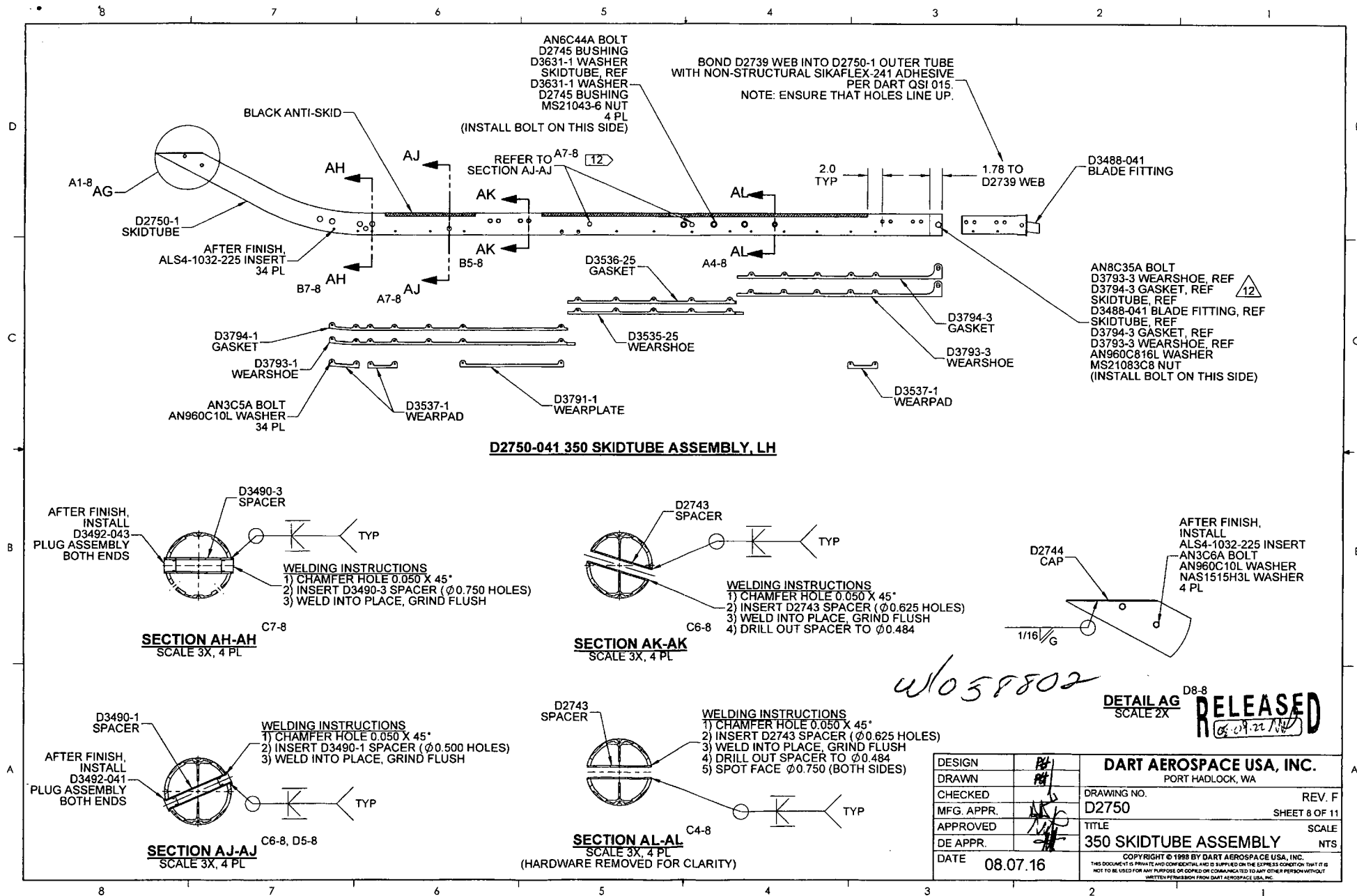
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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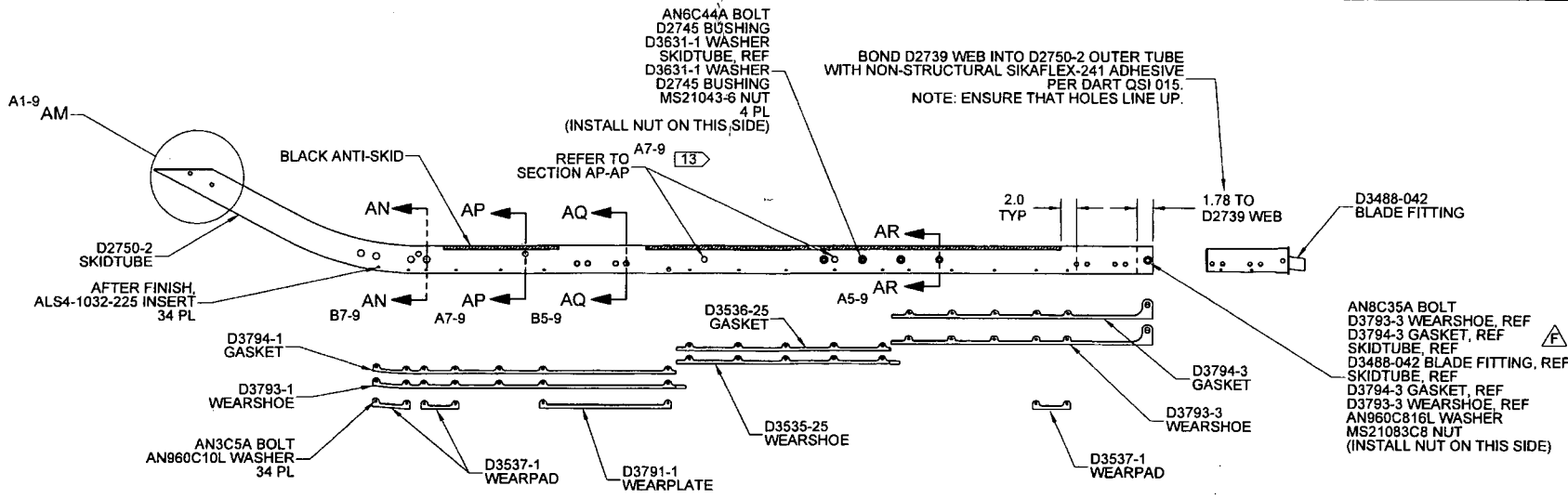
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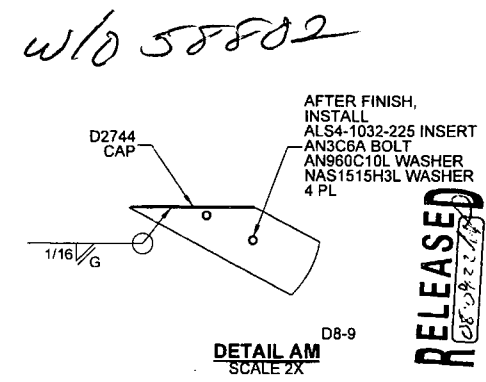
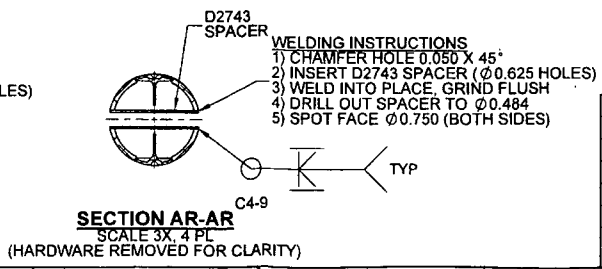
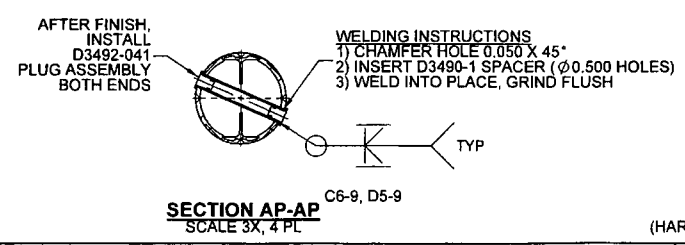
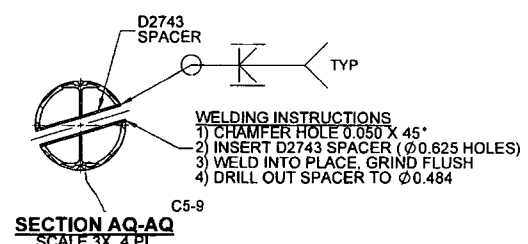
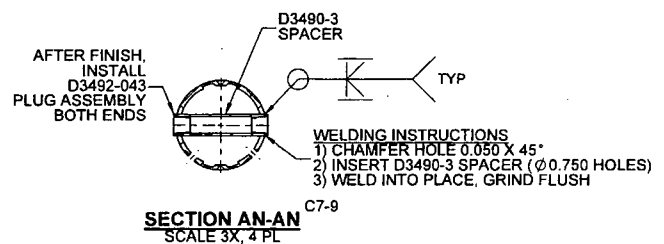
**NOTE:** Date & initial all entries



8 7 6 5 4 3 2 1



**D2750-042 350 SKIDTUBE ASSEMBLY, RH**



DESIGN	PH	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	AC	DRAWING NO.	REV. F
MFG. APPR.	MD	D2750	SHEET 9 OF 11
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC.</small> <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

RELEASED  
08-09-22-16

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

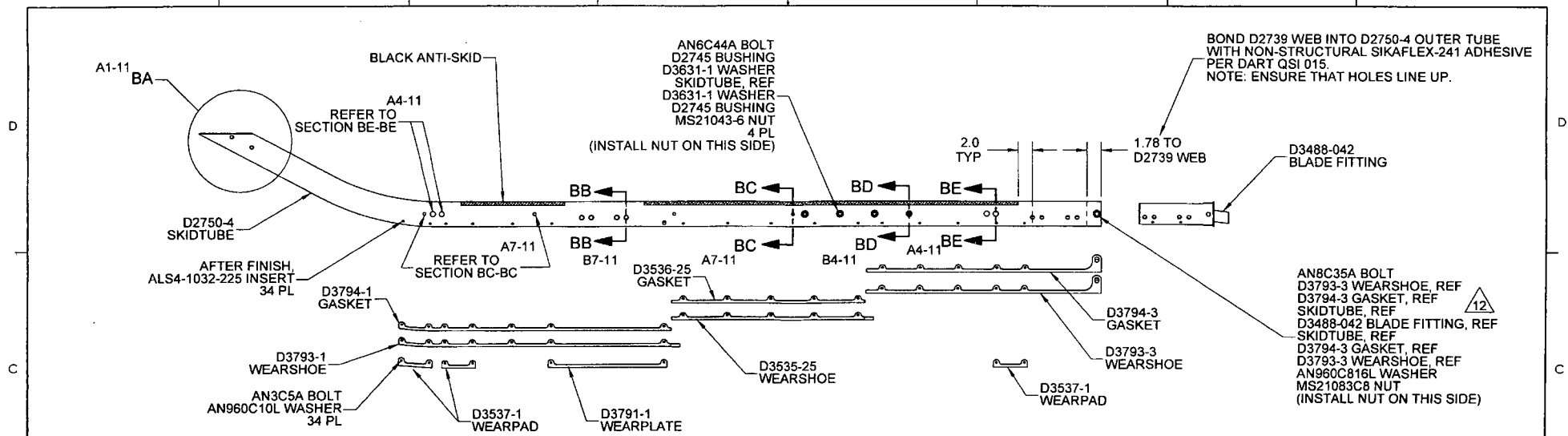
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

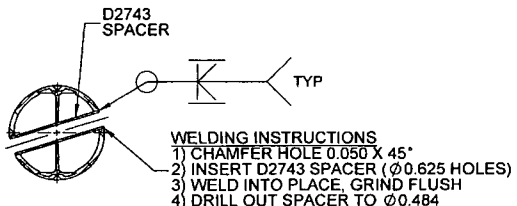
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

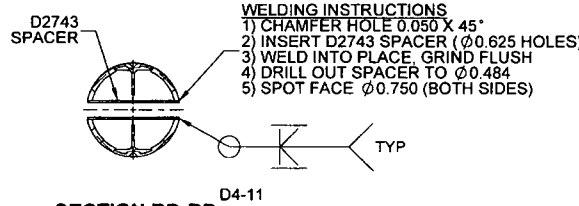
8 7 6 5 4 3 2 1



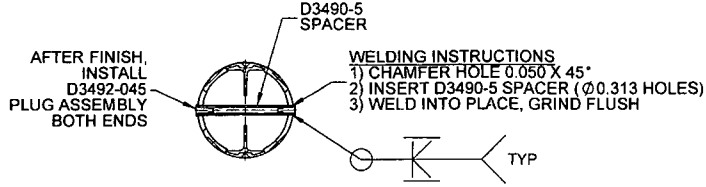
**D2750-044 350 SKIDTUBE ASSEMBLY, RH**



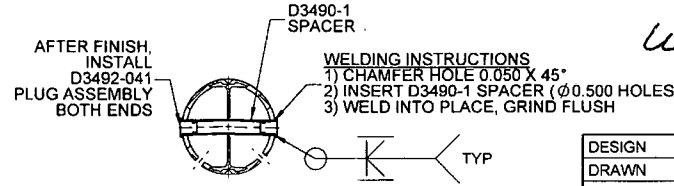
**SECTION BB-BB**  
SCALE 3X, 4 PL



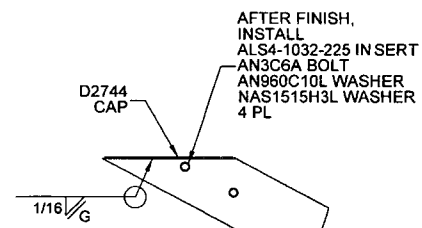
**SECTION BD-BD**  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)



**SECTION BC-BC**  
SCALE 3X, 4 PL



**SECTION BE-BE**  
SCALE 3X, 4 PL



**DETAIL BA**  
SCALE 2X

**RELEASED**  
08-07-16

W/O 58802

DESIGN		<b>DART AEROSPACE USA, INC.</b>
DRAWN		PORT HADLOCK, WA
CHECKED		DRAWING NO. <b>D2750</b>
MFG. APPR.		REV. F
APPROVED		SHEET 11 OF 11
DE APPR.		TITLE <b>350 SKIDTUBE ASSEMBLY</b>
DATE	08.07.16	SCALE NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 229

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 58103  
Part number: D350-626-02  
Description: 350 skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminum  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier John D. G. 1 Date of Test Coupon 10-04-27

Welder Barclay Elliott Date of Test Coupon 10-04-27

The above named individual is qualified in accordance with AWS D17.1.2001 to weld